






Shp May 6



EURO center

Work Order ID 67705


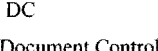
Tuesday, March 29, 2011 1:06:21 PM


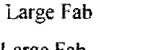


Item ID: D350-591-312 Accept  Setup Start 
Revision ID:
Item Name: Heli-Access-Step, Long RH Stop 
Start Date: 3/29/2011 Start Qty: 10.00  Cust Item ID:
Required Date: 5/6/2011 Req'd Qty: 10.00  Customer:
Reference:

Approvals: Process Plan: H Date: 11-03-29 Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3272	Rev B								

100  DOCUMENT CONTROL 0.00
DC  Memo 0.00
Document Control Photocopy bluefile and type labels as per PPP D350-591-312 CHG001 *S 11/03/15*

110  Large Fab 0.00
Large Fab  Memo 0.00
Large Fab 1-Bevel end for welding FWD ONLY *11.04.28 10 φ*
2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272
A/R Aluminum Rod *M114703*
3-Grind End Plate flush *M115928*

Work Order ID 67705

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Page 2

Item ID:	D350-591-312	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Heli-Access-Step, Long RH					
Start Date:	3/29/2011	Start Qty:	10.00		Cust Item ID:	
Required Date:	5/6/2011	Req'd Qty:	10.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				10	0	86	11/04/28
130 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				10	0		11-04-28
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				10	0		11-04-28

Work Order ID 67705

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Tuesday, March 29, 2011 1:06:21 PM

Item ID: D350-591-312

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Long RH

Start Date: 3/29/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 5/6/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

K11-04-29

10

φ

180

Large Fab

0.00



Large Fab

Memo

0.00

Large Fab

K11-04-29

10

φ

1-Assemble Leg Assembly as per Dwg D3272.

2-Leave one rivet out until welding is complete.

3-Bevel Aft end for welding

SPD 11-04-29

4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSI 004 & Dwg D3272

A/R □ Aluminum Rod □ M114703

6-Grind End Plate flush

A.E.

7-Install last rivet as per Dwg.

Work Order ID 67705

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Page 4

Item ID: D350-591-312

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Long RH

Start Date: 3/29/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 5/6/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00							
200 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
210 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							

S wloslor

S wloslor

X10
PL

X10RM 6 81 u/05/02

Work Order ID 67705

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Page 5

Item ID: D350-591-312

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Long RH

Start Date: 3/29/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 5/6/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

220

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

M 116 964.

Memo

0.00

START TIME: *1:15*

OVEN TEMPERATURE: *320°*

FINISH TIME: *2:45*

10 BR 11-5-3.

230

Wing Walk as per dwg QSI005 4.4 Batch *N1171P4*

0.00



HandFinish

Memo

0.00

Hand Finishing

10RH d Sl 11/05/03

240

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

= 7 m-l 11/05/04 10RH

Work Order ID 67705

Page 6

Tuesday, March 29, 2011 1:06:21 PM

Item ID: D350-591-312

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Long RH

Start Date: 3/29/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 5/6/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/5/45 120

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

S 11/5/45



270

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD350-591-312
Location: _____

Rou B

11/5/45 120

Work Order ID 67705

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Page 7

Item ID: D350-591-312

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Long RH

Start Date: 3/29/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 5/6/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

W/5/9-7

11-05-4
10

Picklist Print

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Page 1

Work Order ID: 67705

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH





Start Date: 3/29/2011

Required Date: 5/6/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A 04.03.22 New issue KJ/RF
 IPP Rev:B 07-06-09 Added D3572-1 JLM
 IPP Rev:C 08-04-02 ECN1163 DD verified by:EC
 IPP Rev:D 08-04-08 ECN1164 DD verified by:EC IPP Rev:D
 fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3272-1 		Manufactured	No			110	Each	0.0000	1	10			
Step													
D3067-1 		Manufactured	No			110	Each	69.0000	1	10			
End Plate													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA016	367582	69				10			
					65969	69							
D3219-1 		Manufactured	No			110	Each	56.0000	2	20			
Plate													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA017	367580	56				20			
					66133	56							
D3066-1 		Manufactured	No			180	Each	53.0000	2	20			
Spacer													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA015	367581	53				20			
					66131	53							

11.04.25 B6773210

11.04.28

11.04.27

11.04.29

Picklist Print

Page 2

Tuesday, March 29, 2011 1:06:27 PM

Work Order ID: 67705

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 3/29/2011

Required Date: 5/6/2011

Start Qty: 10.00

Required Qty: 10.00

MS20600-AD4W4

Purchased

No

180

Each

1,600.000

16

160



Rivets

Location

Loc Qty

Loc Code

ST32I

1500

116188

1500

WA018

100

116712

100

~~117364~~ →

47.0000

1

10

D3065-041

Manufactured

No

180

Each



Step Leg Assembly Hi

Location

Loc Qty

Loc Code

WA014

47

66149

27

66808

20

D3067-1

Manufactured

No

180

Each

69.0000

1

10



End Plate

Location

Loc Qty

Loc Code

WA016

367582

69

65969

69

250

Each

75.0000

2

20

AN3-35A

Purchased

No



Bolt

Location

Loc Qty

Loc Code

ST353

75

116191

75

SAD 11-04-29

9-64
160
96

11.04.29

19

11.04.29

10

117313 11/5/14 (102)

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Shop Packēt Print

Page 2

Picklist Print

Tuesday, March 29, 2011 1:06:28 PM

Work Order ID: 67705

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 3/29/2011

Required Date: 5/6/2011

Start Qty: 10.00

Required Qty: 10.00

D3235-1 Manufactured No

250 Each

67.0000

2 20



Mounting Lug



B67831

Handwritten signature

Location

Loc Qty

Loc Code

ST471

67

65073

7

66941

60

D3278-041 Manufactured No

250 Each

55.0000

1 10



Support Assembly



B677055

Location

Loc Qty

Loc Code

ST471

55

66155

15

66946

40

AN960JD416 NAS1149D0463J Purchased No

250 Each

0.0000

16



Washer



160

M117065

Handwritten signature

AN960JD516 NAS1149D0563J Purchased No

250 Each

0.0000

4



Washer



40

M117291

Handwritten signature

AN5-36A Purchased No

250 Each

97.0000

2



Bolt



20

M117366

Handwritten signature and date 11/14/10

Location

Loc Qty

Loc Code

ST341

97

116704

97

13

Picklist Print

Tuesday, March 29, 2011 1:06:28 PM

Work Order ID: 67705

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 3/29/2011

Required Date: 5/6/2011

Start Qty: 10.00

Required Qty: 10.00

D2618

Manufactured No

250 Each

94.0000

2

20

Bushing

Location

Loc Qty

Loc Code

ST019

94

66942

94

Manufactured No

250 Each

27.0000

4

40

D2230-3

Lug

Location

Loc Qty

Loc Code

Return 2010

4

62927

2

63544

2

ST470

27

66936

27

D2856-400

Manufactured No

250 f

25.5200

1.2

12

Abraison Strip

Location

Loc Qty

Loc Code

ST409

25.52

63735

25.52

cut (2) D2856-400-720 as per dwg

MS21042L3

Purchased No

250 Each

2,189.000

2

20

Nut

Location

Loc Qty

Loc Code

ST300

2189

116391

589

116540

800

116549

800

Picklist Print

Tuesday, March 29, 2011 1:06:29 PM

Work Order ID: 67705

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 3/29/2011

Required Date: 5/6/2011

Start Qty: 10.00

Required Qty: 10.00

AN4-13A

Purchased

No

250

Each

336.0000

8

80

Bolt

Location

Loc Qty

Loc Code

ST357

336

116786

36

117094

300

MS21042L5

Purchased

No

250

Each

941.0000

2

20

Nut

Location

Loc Qty

Loc Code

ST300

941

115594

181

116105

500

116548

260

MS21042L4

Purchased

No

250

Each

3,324.000

8

80

Nut

Location

Loc Qty

Loc Code

ST300

3324

116188

1324

116823

2000

AN960JD10

NAS1149D0363J

Purchased

No

250

Each

0.0000

4

40

Washer

DART

DESIGN <i>9P</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED07.06.04 *H*△
B

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

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RETURN TO
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WITHOUT NOTICE
WORK ORDER
NO. *6-7705*

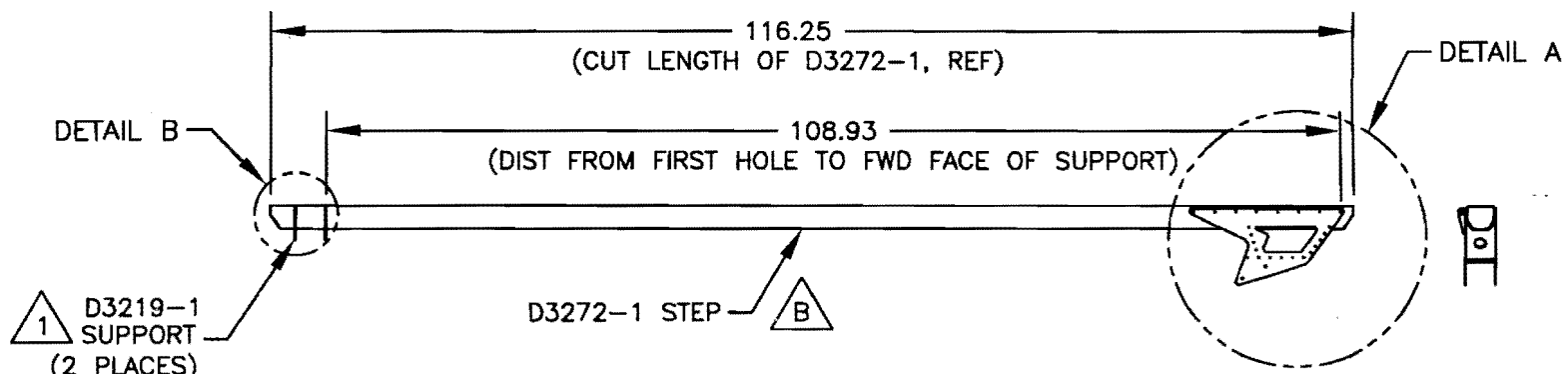
11-03-29
11-03-29

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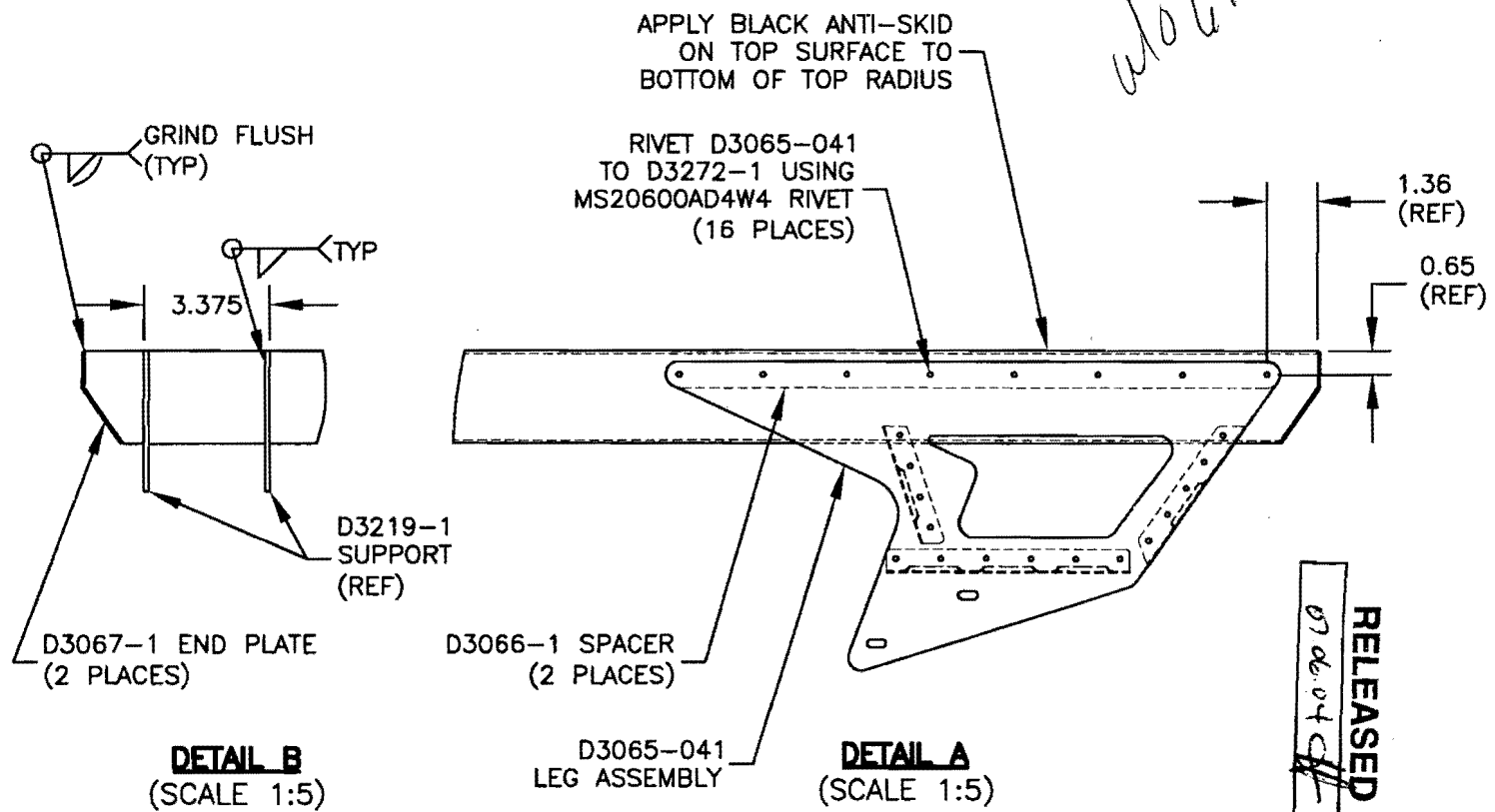
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DESIGN	APPROVED	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.	REV. B
DATE		D3272	SHEET 2 OF 3
07.05.18		STEP ASSEMBLY, HI LONG	SCALE 1:20



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



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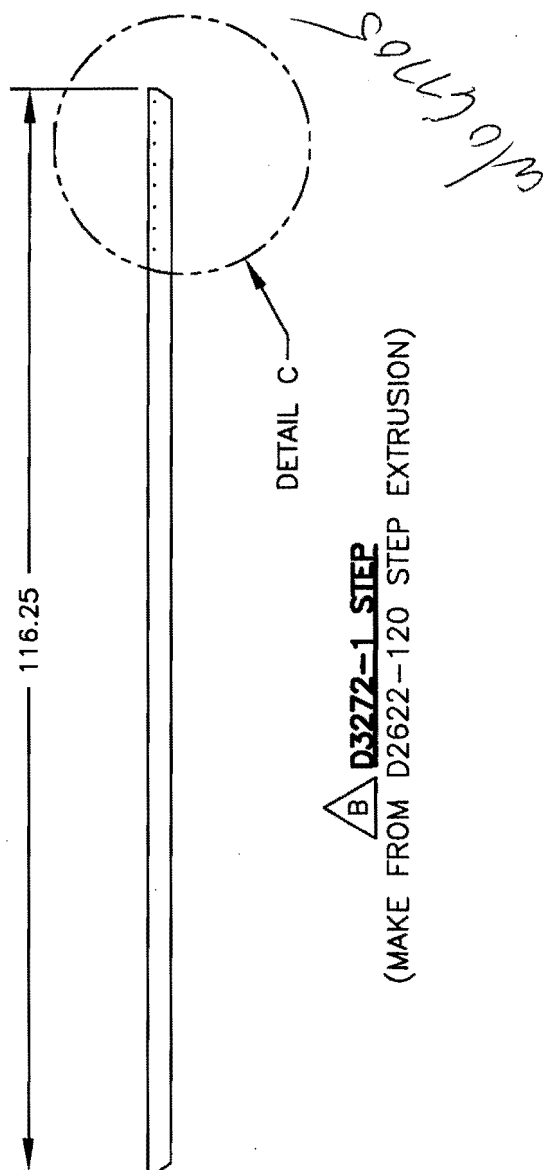
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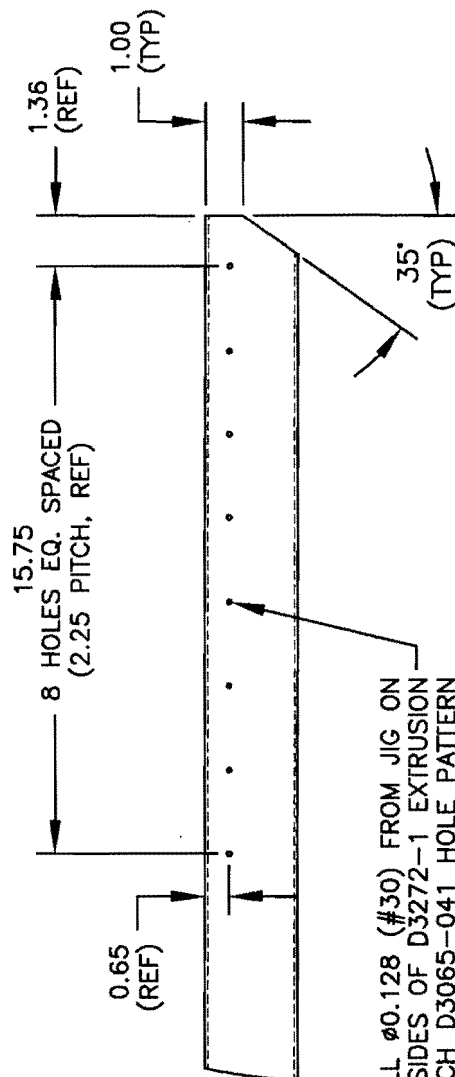
DESIGN <i>CP</i>	DRAWN BY <i>JB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

RELEASED

07.06.04 *[Signature]*



B D3272-1 STEP
(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL $\phi 0.128$ (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

DETAIL C
(SCALE 1:5)

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Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
	X							D350-591-212	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
		X						D350-591-213	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
			X					D350-591-214	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
				X				D350-591-215	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
					X			D350-591-216	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
						X		D350-591-311	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
							X	D350-591-312	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.